



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2939-2

Job Sheet 180981



Part No: D2939-2

Job Qty: 4 ea

Part Name: Saddle RH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		8/3/18	0.00	0.00	Start Up Machining-1		SB 18/08/01
100	CNC Vertical Machining	4 pcs		8/3/18	0.00	3.74	HAAS1-2		VB 18/08/13
110	Mill Conv	4 pcs		8/3/18	0.00	0.20	Mill Conv 1		
120	QC	4 pcs		8/3/18	0.00	0.00	QC21		
130	QC	4 pcs		8/3/18	0.00	0.00	QC8 Machining-1		man L 18/08/01
140	HandFinish	4 pcs		8/3/18	0.00	0.10	HandFinish1		D.R. 18/08/16
150	Powdercoat	4 pcs		8/3/18	0.00	0.13	Powdercoat1		18/08/13
160	QC	4 pcs		8/3/18	0.00	0.00	QC3		AUG 17 2018
170	Packaging	4 pcs		8/3/18	0.00	0.00	Packaging3-1		9-85 AUG 24 2018
180	QC21-SA	4 Ea		8/3/18	0.00	0.00	QC21		9-85 AUG 24 2018

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMM A021.

150 - START TIME: 8:00am 320F 8:30am

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	5098395

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	4	77	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube</td><td style="width:5%;">☐</td> <td style="width:15%;">Cross tube</td><td style="width:5%;">☐</td> <td style="width:15%;">Water Jet</td><td style="width:5%;">☐</td> <td style="width:15%;">Engineering</td><td style="width:5%;">☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>						Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐		
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Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval																																		
Description Work Order Deviation				Disposition				Completed By																																	
DART Aerospace Ltd. 1270 Aberdeen Street Haverhill, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaero.com Date: 08/01/18 Container No: S098400 Part: D2939 - 2 Job No: 180981 Serial No/Batch: S098400 Revision: Inspector: Exp Date: Instructions: Various STC's er Loss/Surge y/Program n d ng Stock Pulled of Sequence set				Rushing Product Improvement Process Improvement Manufacturing Process Past Due Heat Treat Wave/Twist in Tube Marks/Chatter Cut Too Short Instructions Incomplete/Unclear Drill Holes				Lead hand / Supervisor Approval Verification																																	
								QC / QA Coordinator Approval																																	
								Positioned Wrong																																	
Outside Dimensions																																									
Over/Under tolerance																																									
Part Incorrect																																									
Part Lost/Missing																																									
Part Moved																																									
Drawing																																									
Finish																																									
Misread																																									
Turning Sequence																																									

DART AEROSPACE LTD				Work Order: 180981	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.126	0.126	0.126	0.126	
B	0.100	0.140		0.126	0.126	0.126	0.126	
C	0.100	0.140		0.113	0.113	0.114	0.114	
D	0.210	0.230		0.226	0.226	0.226	0.226	
E	1.245	1.255 /		1.250	1.250	1.25	1.25	
F	1.245	1.255 /		1.250	1.250	1.250	1.25	
G	2.495	2.505 /		2.50	2.50	2.50	2.50	
H	0.510	0.515		0.511	0.511	0.511	0.511	
I	1.572	1.582 /		1.577	1.577	1.577	1.577	
J	2.495	2.505 /		2.50	2.50	2.50	2.50	
K	0.257	0.262 /		0.257	0.257	0.257	0.257	
L	0.312	0.317 /		0.312	0.312	0.312	0.312	
M	0.235	0.240		0.236	0.237	0.237	0.237	
N	0.100	0.140		0.126	0.126	0.126	0.126	
O	0.540	0.560		0.551	0.550	0.550	0.551	
P	0.490	0.510		0.502	0.504	0.503	0.504	
Q	3.715	3.725 /		3.72	3.72	3.72	3.72	
R	2.720	2.760 /		2.492	2.492	2.492	2.492	
S	0.240	0.270		0.256	0.255	0.255	0.255	
T	0.100	0.180 /		0.127	0.127	0.127	0.127	
U	1.625	1.635 /		1.63	1.63	1.63	1.63	
V	1.362	1.372 /		1.367	1.367	1.367	1.367	
W	0.316	0.321 /		0.316	0.316	0.316	0.316	
X	1.250	1.270 /		1.260	1.26	1.26	1.26	
Y	1.565	1.585 /		1.575	1.575	1.575	1.575	
Z	0.178	0.198 /		0.188	0.188	0.188	0.188	
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by:		Date:	
Audited by: mml		Date: 18/08/08	
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					